

Work Order ID 127149

December-09-14 11:15:50 AM

127149

Page 1

Item ID: D5122-1TRN

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Center Support, Upper, Turning Detail

Start Date: 16/12/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/12/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5122	A

100	MORI SEIKI CNC LATHE LARGE	0.00
100		
Doosan	Memo	0.00
Doosan Lathe	Turn blank as per Folio FB325	

4 0 DAS 40 9-89 15-1-27
15/01/26

110	QC2- Inspect parts off machine FAI/FAIB	0.00
110		
QC	Memo	0.00
Quality Control		

4 0 DAS 40 9-89 15-1-27
15/01/26

120	QC8- Inspect parts - second check	0.00
120		
QC	Memo	0.00
Quality Control		

4 0 DAS 44 9-89 15/01/27

Work Order ID 127149

December-09-14 11:15:50 AM

127149

Page 2

Item ID: D5122-1TRN Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Center Support, Upper, Turning Detail
 Start Date: 16/12/2014 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 23/12/2014 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS
130	Packaging					4	0		44 15/01/27 9-89
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>HAT 060</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15/1/28 *[Signature]*

[Signature] 15.1-27

Picklist Print

December-09-14 11:15:48 AM

Page 1

Work Order ID: 127149

127149

Parent Item: D5122-1TRN

D5122-1TRN

Parent Item Name: Center Support, Upper, Turning Detail

Start Date: 16/12/2014

Required Date: 23/12/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A NEW ISSUE JFS 14/07/09 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	2.0000	1	4			DAS
D6104-011									**			15/01/26	40
17-4 SS Roundbar 6.50"OD													9-89

Location

Loc Qty

Loc Code

MAT043

2

106719

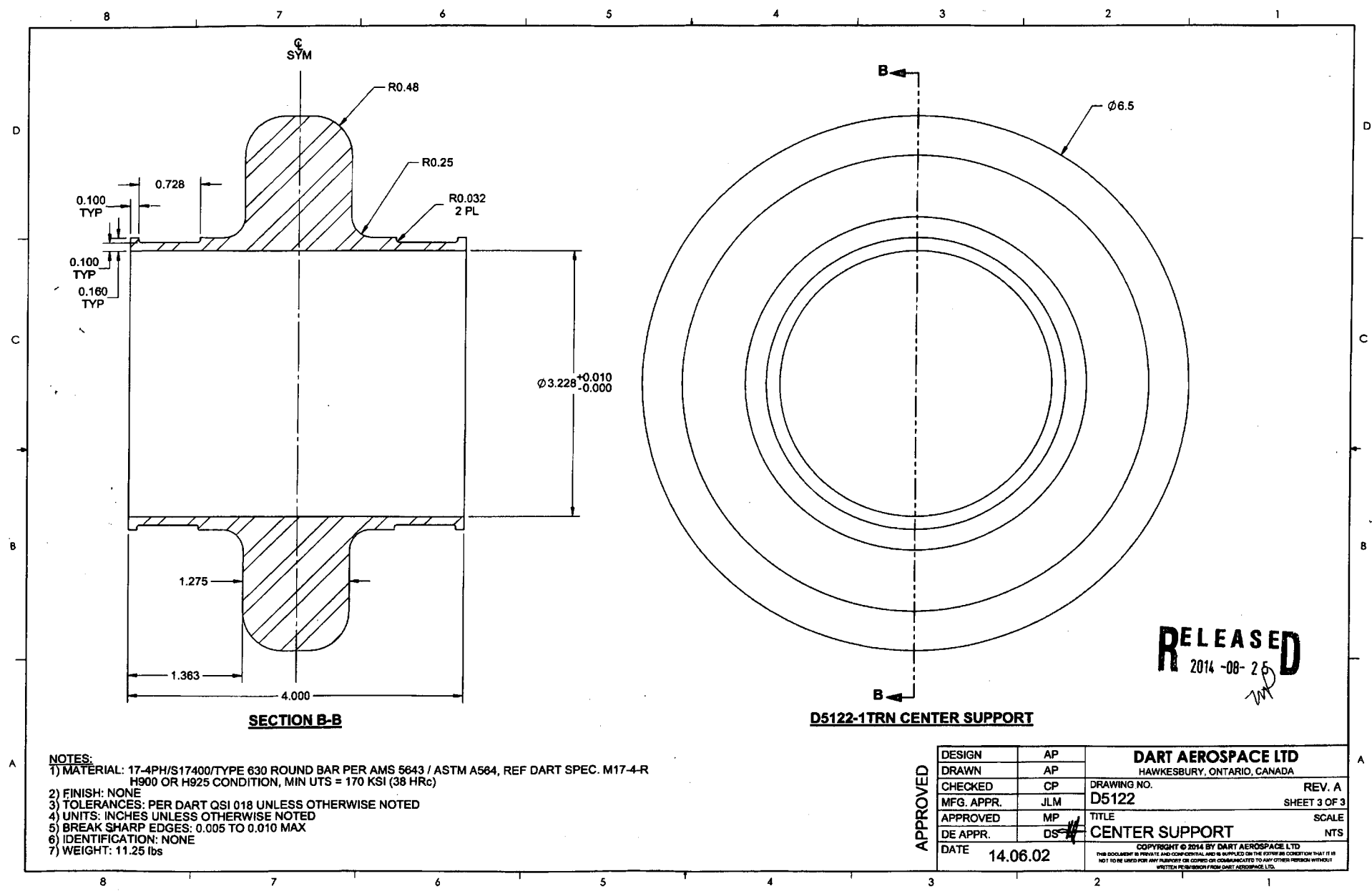
1

120229

1

→ 127419

4



RELEASED
2014-08-25
W

- NOTES:**
- 1) MATERIAL: 17-4PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 11.25 lbs

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	CP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5122	SHEET 3 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	CENTER SUPPORT	NTS
DATE		14.06.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

